

Amendments to the Specification:

Please replace paragraph [0002] with the following paragraph:

[0002] Machining work pieces by rotary cutting tools may cause objectionable vibrational harmonics to occur. This results in chatter and other phenomena which may cause flaws in the machined product. It is not desirable to alter rotational speeds of a machine tool and rate of advance speeds of a cutting tool as such steps may interfere with optimal productivity. It is known to vary circumferential spacing of inserts and their pockets in a rotary cutting tool to break up harmonics which might otherwise occur. This approach is shown in United States Patent Numbers 4,092,082, issued on May 30, 1978, to Severson, and ~~4,093,392, issued on June 6, 1978, to Hopkins~~. It is also known to vary rake angles among inserts, as shown in United States Patent Number 4,844,666, issued on July 4, 1989, to Tsujimura et al., and 5,913,644, issued on June 22, 1999, to DeRoche et al., of common ownership with the present application. The prior art does not show or suggest the novel combinations of insert orientation within a rotary cutting tool as claimed.

Please replace paragraph [0022] with the following paragraph:

[0022] In the preferred embodiment, each pocket 16 is conventionally associated with flutes 24, 26, or 28. Therefore, it may be said that one flute 24, 26 or 28 is spaced apart from the others at irregular intervals, it necessarily following that pockets 16 and inserts 2 of any one row consequently also being irregularly spaced apart. In the embodiment of Fig. 1, there are three helical flutes 24, 26, or 28. In the first row, that being at the bottom of tool 10 as depicted in Fig. 1, flutes 24, 26, and 28 are spaced at intervals of 119 degrees, 120 degrees, and 121 degrees about the periphery of tool 10, as viewed in end elevation (for example, see Fig. 2). In the next row, spacing intervals of equal magnitude are provided, but are staggered from the first row such that pockets 16 of different flutes are spaced 120 degrees apart, compared to pockets 16 of those flutes spaced apart by 119, 120, and 121 degrees in the first row. The same principle is extended to succeeding rows of pockets 16. In the third row, spacing of flutes 24, 26, and 28 are 119.25 degrees, 120 degrees, and 120.75 degrees. In the fourth row, flute spacing is again 119 degrees, 120 degrees, and 121 degrees, but staggered from the arrangement of the first row. In the fifth row, flute spacing is 120.75 degrees, 120.75 degrees, and 118.5 degrees. Of course, other intervals may be substituted if desired, provided the spacing acts to break up harmonic vibrations.